* 1	er ID 91675 r 15, 2012 10:19:44 .	4M		*916		4500	00 "	Page 1			
Revision ID:	D350-740-011 Dual Disabling			Accept	*N900	040	100) *	Setup Star Stop	1.7	S1* S2*
Start Date: Required Date: Reference:		Qty: 4.00 Qty: 4.00	*4* *4*		Cust Item Customer:						. ,,
Approvals:	Process Plan:	W	Date: 2-10-15	Tooling:	D	ate:		I	Run Star	I <i>Z</i> I	R1*
	QC:		Date:	_ SPC (Y/N):	D	ate:			Stop	[ື] *N	R2*
Sequence ID/ Work Center ID	Operat Descrip			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nb	r						-			
N/A	Rev N/A		v <>> .								
100				0.00	(2AC)					·	
100	DOCUM	ENT CONTR	OL		()AS)	رعالاه			MIC	5 17	-10-25
DC		Memo		0.00					70,0		
Document Control		Photocopy	bluefile and create labels po	er PPP D350-740-011 CH	IG002						1
110	Pick Kit			0.00							•
110 Packaging Packaging		Memo		0.00				_4x_			12-10-
	·										
*120 *120*	QC4-100	% Inspect kits	for completeness	0.00							
QC		Memo		0.00							
Quality Control		Ensure that 041 assemb	keys can be locked and unlily.	ocked for each D3371-04	11 and D3372- AS	rolus	ما2	((th))			

NCR:	Yes	1	No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:_	Date: _	Mary Company
QA Closed:	Date:	
ARTMENT/P	PROCESS	
	Water Jet Eng. Coor. /Packaging Supplier	Engineering Quality Other
Sign &		

									QA Closed:	Date:			
Work Order:					DISPOSITION			AGAINST DE	PARTMENT,	/PROCESS			
Part No. Scrap Use-as-is NCR No. Work Order Update						Ther	Skid-tube Crosstube Water Jet Engineering Machining Small Fab Prod. Eng. Coor. Quality Thermoforming Finishing Rec/Store/Packaging Othe Large Fab Composite Supplier						
Root				Descri	ption of work order update	Initial	Α	ction	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chief En	Des	cription	Date	Verification	QC Inspector		
Doc/Data													
Equip/Tooling													
Operator	_												
Material													
Setup													
Other	_												
Process													
Supplier	_				, ۶,	1							
Training	4	ŀ											
Unapproved		<u> </u>	<u> </u>	<u></u>				· · · · · · · · · · · · · · · · · · ·					
1						AULT CAT	EGORY						
Landing				_	General	П .			1	_	7		
<u> </u>	Bending				Bend	Grain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced		
<u> </u>	-	Not Conce	ntric to	O/S	BOM/Route	Hardv		_	Over/Under	<u> </u>	Temperature/Cure		
<u> </u>	Cracks			-	Broken/Damaged	—	tion Incomplete		Part Incorre	}	Weld		
<u> </u>	⊣	/Crimped			Burrs	\vdash	ctions Incomplete	2/Unclear	Part Lost/M	issing	Wrong Stock Pulled		
-	Cuffs				Contamination	\vdash	enance	<u> </u>	Part Moved	A f = = = =			
<u> </u>	Heat Treat			-	Countersink	Mislal		 	Positioned \	· -	7 ₀₄ ,		
<u> </u>	├ ─┥				Cut Too Short	Misre		L	Power Loss/	Surge	Other		
<u> </u>	Ripples in Bend Drill Holes Torque Waves in Extrusion Drawing						Offset						
<u> </u>	⊣ '			n	Drawing		Calibration		 				
-	⊣ "	Sequence		<u> </u>	Finish ·	_	Out of Sequence			·			
	Wave/Twist in Tube				Folio	Outsid	le Dimensions						

Work Orde				*916			Page 2				
Item ID: Revision ID: Item Name:	D350-740-01			Accept	*N900	<u>040</u>	100	ገ*	Setup Star	1.	IS1* IS2*
Start Date: Required Date: Reference:	10/15/2012 10/26/2012	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:					
Approvals:	Process Pla	ın:	Date:	Tooling: SPC (Y/N):		ate:			Run Star Stop		IR1* IR2*
Sequence ID/ Work Center II 130 *120* Packaging Packaging)	per PPP D35	G RESOURCE #1 50-740-011Location:	Set Up/ Run Hours 0.00 0.00 Identify and pack for PPP		Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control		Rev:041 QC21- Final Inspection - Memo	D3372-041	SH,R 0.00					MCS	T_12	M512-10-2

										DQA:	Date:	`
NCR:	/es	/ No				WORK ORDER NON-	COI	NFOR	MANCE / UPDATE	QA Closed:	Date:	7
							_			QA Closed.	Date.	
Work Orde	er:					DISPOSITION			AGAINST D	EPARTMENT/	PROCESS	
				····		Rework	1		Skid-tube Crosstube	7	Water Jet	Engineering
Part N	No.					Scrap	1		Machining Small Fab	Prod	d. Eng. Coor.	Quality
						Use-as-is	1		noforming Finishing	⊣	e/Packaging	Other
NCR N	٧o.					Work Order Update	1		Large Fab Composite		Supplier	
Root					Descri	ption of work order update		nitial	Action	Sign &		
Cause		Date	Step	Qty	:	or Non-conformance	Ch	ief Eng	Description	Date	Verification	QC Inspector
oc/Data												
quip/Tooling											, 	
perator					-						i I	
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etup										1	1	
Other											· 	
rocess												
upplier												
raining	_		!									
Inapproved	<u> </u>								<u></u>		<u> </u>	
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Landi	ng (7			<u> </u>	General		1	г	٦		J
	┡	Bending			_ -	Bend	\vdash	Grain	1	Ovalized	-	Pressure/Forced
	┡	Centre No	ot Concer	ntric to	^{U/S} -	BOM/Route	-	Hardwa	-	Over/Under	<u> </u>	Temperature/Cure
	_	Cracks	C .:		-	Broken/Damaged	\vdash	-i '	ion Incomplete	Part Incorred	 	Weld
	-	Crushed/0	crimpea.		<u> </u>	Burrs	\vdash	1	tions Incomplete/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs		Contamination	\vdash	Mainte Mislabe	ļ .	Part Moved Positioned V	Mrong				
	Heat Treat Inspection Strip in Tube			Cut Too Short	\vdash	Misrea	<u> </u>	Power Loss/	_	Other		
	\vdash	Ripples in		rube	-	Drill Holes	-	Offset	<u>'</u>		Juige	Other
	\vdash	Torque W		Evtrusia	, <u> </u>	Drawing	-	4	Calibration			
	\vdash	1			" ├	Finish	\vdash	4	Sequence			
	•	I CALLUING J	urning Sequence			ti iiiisii		TOULUI.	Jequence			

Outside Dimensions

Wave/Twist in Tube

Folio

Page 1

Status

Work Order ID:

91675

Parent Item:

D350-740-011

Parent Item Name:

Dual Disabling

Start Date: 10/15/2012

Required Date: 10/26/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:E

Re-Format

Manufactured

06-01-13

No

JLM

				V151.11									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	-
Pedal Lock Assembly	,	Manufactured	No			120	Each	1.0000	0	4	9/67	6/	_

Location ST490A

Loc Oty

Loc Code

89130

110

Each

0.0000

4 916 M (4)

												DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-C	O	NFORM	MANCE / UP	DATE	QA Closed:	Date:	
						_		_				QA Closed.	Date.	
Vork Ord	er:					1	DISPOSITION	ı			AGAINST DE	PARTMENT/	PROCESS	
	_					١	Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part	No.						Scrap			Machining	Small Fab	Proc	d. Eng. Coor.	Quality
			•				Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR	NCR No.					Work Order Update			Large Fab	Composite]	Supplier		
								•						
Root				1	Desc	•	tion of work order update		nitial		ction	Sign &		
Cause	_	Date	Step	Qty		or Non-conformance			ief Eng	Desc	ription	Date	Verification	QC Inspector
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upplier	_													
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Land	Ing (Bending			Г	_	Bend		Grain			Ovalized		Pressure/Forced
	\vdash	Centre No	at Concer	ntric to 1	n/s		BOM/Route	\vdash	Hardwa	ro	<u> </u>	Over/Under	tolerance	Temperature/Cure
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	-	Crushed/0	Crimned				Burrs	\vdash	ł	ions Incomplete	/Unclear	Part Lost/Mi	 	Wrong Stock Pulled
		Cuffs	compeu.		+	1	Contamination	\vdash	Mainte	•	Jonata	Part Moved	1331118	
	Heat Treat				Countersink	\vdash	Mislabe		ļ	Positioned V	Vrong			
	Inspection Strip in Tube				Cut Too Short		Misread		<u> </u>	Power Loss/		Other		
		Ripples in	•				Drill Holes	-	Offset		<u> </u>			1
		Torque W		xtrusio	, t		Drawing		4	Calibration				
		Turning Sequence				Finish		1	Sequence					

Outside Dimensions

Wave/Twist in Tube

Folio



- 3.3.3 Place the D3384-043 Collective Sock over the collective control stick as shown in Figure 2.
- 3.3.4 Unlock/open the collective lock and secure around the aircraft collective control base by aligning the shaft of the lock device with the hole in the collective base as shown in Figure 2. Engage cam and lock D3372-051/ D3400-051 Collective Lock Assembly with the provided key. Ensure that the device is locked and will not open.

D3372-041/ D3400-041 COLLECTIVE DISABLING KIT REMOVAL 3.4

- 3.4.1 Unlock D3372-051/ D3400-051 Collective Lock Assembly from the collective control base using the provided key. Open the lock, and remove from the collective control base.
- 3.4.2 Remove D3384-043 Collective Sock from the collective control stick.

4.0 PARTS LIST

(0117)	-013	Part Number	Description
Х	···	D350-740-011	DUAL DISABLING KIT
	X	D355-740-013	DUAL DISABLING KIT
11	1	D3371-041	TAIL ROTOR PEDAL DISABLING KIT
-1	1	D3371-051	* PEDAL LOCK ASSEMBLY
1	1	D3384-045	* CYCLIC SOCK
1	1	HX-81	* ¼" –20 SOCKET HEAD CAP SCREW
2	2	AN960-416	* WASHER
1	1	D3373-7K	*** KEY, REPLACEMENT
/1		D3372-041	COLLECTIVE DISABLING KIT
1		D3372-051	* COLLECTIVE LOCK ASSEMBLY
1		D3384-043	** COLLECTIVE SOCK
1		HX-81	** 1/4" -20 SOCKET HEAD CAP SCREW
2		AN960-416	** WASHER
1		D3373-1K	*** KEY, REPLACEMENT
	1	D3400-041	COLLECTIVE DISABLING KIT
	1	D3400-051	* COLLECTIVE LOCK ASSEMBLY
	1	D3384-043	** COLLECTIVE SOCK
	1	HX-81	** 1/4" -20 SOCKET HEAD CAP SCREW
	2	AN960-416	** WASHER
	1	D3373-1K	*** KEY, REPLACEMENT

^{*} shown for reference only, part is included in D3371-041 assembly above

^{**} shown for reference only, part is included in D3372-041/ D3400-041 assembly above

^{***} shown for reference only, p/n for ordering replacement keys